

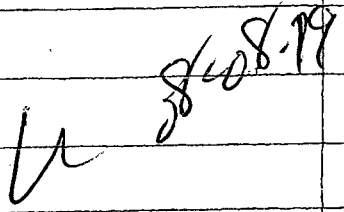
DART AEROSPACE LTD		Work Order:	39952
Description: BASE ASSEMBLY		Part Number:	B67-43001-65
Dwg: B67-43001	SHEET 15	Qty:	3
		Page of	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	GA	CUT ALL 1" x 1" SQUARE TUBING M18601 = 3 - 139 = 12.0469' LONG WITH ANGLES @ 76.5° DEBUR	h	08-06-25	3
3	GA	- 141 = 11.00' LONG WITH 76.5° ANGLE ONE END AND 58.5° ANGLE OTHER END - DEBUR	h	08-06-25	2
4	WA	- 143 = 17.50' LONG WITH 58.5° ANGLE ONE END. MARK HOLES + DRILL AS PER DWG. DEBUR	h	08-06-25	2
5	WA	MOUNT PARTS IN WELDING JIG AND WELD DEBUR	h	08-06-25	
6	GA	IDENTIFY AS B67-43001-65	h	08-06-25	
6	WA	CUT D3440-11 AS PER DWG. DEBUR			
7	WA	WELD D3440-11 TO ASSY. N/A W			
9	QCS/9	Droped work/weld			
10	SI	Identify = Stock			
11	DC	Level 21 Close w/o			

PRELIMINARY ISSUE

Rev	Date	Change	Revised By	Approved

DART AEROSPACE LTD		Work Order:	39952
Description: INNER TUBE		Part Number:	D67-43001-25
Dwg: D67-43001		Qty:	257
SHEET 23		Page 1 of 1	

Step	Location	Procedure	By	Date
1	DC	Issue Traveller		
2	GA	PICK 1.25" OD x 0.125" WALL 6061-T6, WW-T-60016 AL. TUBING. CUT TO 47.70" LONG. M18641	PH	08.06.21.5
3	GA	DRILL Ø 1.00" HOLE AS PER DWG.	PH	08.07.01.5
4	GA	PICK D67-43001-249 (i) M18147	PH	08.07.08.5
5	WA	INSERT D67-43001-249 INTO D67-43001-257 TUBE AND WELD AS PER DWG.	PH	08.07.08.5
6A	GA	GRIND AND DEBURR FLUO TO CIRCUMFERENCE OF TUBING.	SAD	08.07.15.0
7	GA	IDENTIFY PART AS D67-43001-257.	PH	08.07.29.5
bb	QCS	Inspect Level 5		
PRELIMINARY ISSUE				
				

Rev	Date	Change	Revised By	Approv
		New issue	EL	EL